

Work Order ID 67664

Tuesday, March 29, 2011 9:24:18 AM



Page 1

Item ID: D2571

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd Out 205

Stop



Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *11-03-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2571	Rev E

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. *67664* Double check by: *MF* ☐ 1-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA051 and inspect

B.A 11/05/04
J.F.S.

12 *0*

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2571 & D2572

B.A 11/05/04
J.F.S.

12 *0*

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

B.A 11/05/04
J.F.S.

12 *0*

Work Order ID 67664

Tuesday, March 29, 2011 9:24:18 AM



Page 2

Item ID: D2571

Accept



Setup Start



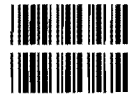
Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 11/05/05

(12)



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 x SL 11/05/05

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

FINISH TIME:

OVEN TEMPERATURE:

10:40

320°

11:10

(12x) M-L 11/05/07

N1 116964

Work Order ID 67664

Page 3

Tuesday, March 29, 2011 9:24:18 AM

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAD
11-05-07

170

Identify as per dwg & Stock Location: 2/33

0.00



Packaging

Memo

0.00

Packaging

11/15/09 (12)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/15/09

MF
11-05-09

Picklist Print

Tuesday, March 29, 2011 9:24:16 AM

Page 1

Work Order ID: 67664



Parent Item: D2571



Parent Item Name: Saddle, Fwd Out 205

Start Date: 3/30/2011

Required Date: 4/13/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	53.0000	1	12			

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

20

66967

20

MAT045

33

65383

13

65954

20

12

J.F.S

DART AEROSPACE LTD	Work Order: 67664
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441"	0.441"	0.442"	0.442"	Vern.	J.F.-05
B	1.745	1.755		1.748"	1.748"	1.750"	1.747"	"	
C	3.495	3.505		3.499"	3.499"	3.498"	3.498"	"	
D	1.745	1.755		1.750"	1.749"	1.750"	1.750"	"	
E	7.990	8.010		8.000"	8.000"	8.001"	8.000"	Vern.	CNC-02
F	0.490	0.510		0.503"	0.502"	0.506"	0.500"	Vern.	J.F.-05
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"	"	
H	0.375	0.380		0.376"	0.376"	0.376"	0.376"	"	
I	0.490	0.510		0.500"	0.500"	0.499"	0.500"	"	
J	1.174	1.184		1.181"	1.181"	1.181"	1.181"	"	
K	0.558	0.578		0.566"	0.566"	0.565"	0.566"	"	
L	1.174	1.184		1.179"	1.182"	1.182"	1.182"	"	
M	1.490	1.500		1.498"	1.498"	1.498"	1.498"	"	
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"	"	
O	3.869	3.879		3.874"	3.870"	3.876"	3.876"	"	
P	0.115	0.135		0.126"	0.125"	0.124"	0.124"	Mic	J.F.-04
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"	Vern.	J.F.-05
R	0.240	0.260		0.254"	0.254"	0.254"	0.253"	Mic	J.F.-04
S	0.115	0.135		0.127"	0.133"	0.129"	0.129"	Mic	118-120
T	0.178	0.198		R0.188"	R0.188"	R0.188"	R0.188"	R.G.	Ref.
U	2.940	2.980		2.960"	2.961"	2.961"	2.961"	Vern.	J.F.-05
V	0.230	0.250		0.238"	0.245"	0.240"	0.240"	"	J.F.-05
W	0.115	0.135		0.121"	0.127"	0.123"	0.120"	Mic	118-120
X	0.308	0.313		0.311"	0.310"	0.310"	0.310"	Mic	J.F.-04
Y	0.760	0.765		0.764"	0.763"	0.763"	0.763"	Vern.	J.F.-05
Z	0.352	0.372		0.367"	0.363"	0.363"	0.365"	Mic	118-120
AA	0.470	0.530		R0.500"	R0.500"	R0.500"	R0.500"	R.G.	Ref.
AB	0.615	0.635		0.623"	0.624"	0.624"	0.623"	Vern.	J.F.-05
AC	0.053	0.073		R0.063"	R0.063"	R0.063"	R0.063"	R.G.	Ref.
AD	0.240	0.260		0.247"	0.260"	0.260"	0.255"	Mic	118-120
AE	1.375	1.395		1.392"	1.384"	1.388"	1.389"	Dial	HAAS#2
AF	0.115	0.135		0.135"	0.135"	0.135"	0.135"	Vern.	J.F.-05
AG	0.240	0.280		0.275"	0.275"	0.275"	0.275"	"	
AH	0.240	0.260		0.248"	0.256"	0.251"	0.253"	Mic	118-120
AI	2.000	2.020		2.007"	2.000"	2.003"	2.004"	Dial	HAAS#2
AJ	0.023	0.043		0.033"	0.033"	0.033"	0.033"	Vern.	J.F.-05
Accept/Reject									

Measured by: J.F.S.
Date: 11/05/03

Audited by: [Signature]
Date: 11/05/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order:	67689
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		0.442"	0.442"	0.442"	0.442"	vern.	J.F-05
B	1.745	1.755		1.750"	1.750"	1.747"	1.750"	"	
C	3.495	3.505		3.497"	3.499"	3.500"	3.500"	"	
D	1.745	1.755		1.751"	1.748"	1.744"	1.750"	"	
E	7.990	8.010		8.001"	8.000"	8.000"	8.000"	vern.	CNC-02
F	0.490	0.510		0.502"	0.502"	0.503"	0.502"	vern.	J.F-05
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"	"	
H	0.375	0.380		0.376"	0.376"	0.376"	0.376"	"	
I	0.490	0.510		0.500"	0.501"	0.498"	0.500"	"	
J	1.174	1.184		1.179"	1.174"	1.179"	1.179"	"	
K	0.558	0.578		0.568"	0.568"	0.565"	0.567"	"	
L	1.174	1.184		1.180"	1.180"	1.179"	1.180"	"	
M	1.490	1.500		1.496"	1.496"	1.496"	1.496"	"	
N	2.495	2.505		2.501"	2.501"	2.500"	2.500"	"	
O	3.869	3.879		3.875"	3.875"	3.875"	3.875"	"	
P	0.115	0.135		0.127"	0.125"	0.125"	0.126"	Mic	J.F-04
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"	Mic	J.F-05
R	0.240	0.260		0.253"	0.252"	0.252"	0.252"	Mic	J.F-04
S	0.115	0.135		0.127"	0.128"	0.128"	0.125"	Mic	118-120
T	0.178	0.198		0.188"	0.188"	0.188"	0.188"	R.G.	Ref.
U	2.940	2.980		2.961"	2.961"	2.961"	2.961"	vern.	J.F-05
V	0.230	0.250		0.239"	0.238"	0.240"	0.237"	"	
W	0.115	0.135		0.119"	0.121"	0.120"	0.120"	Mic	118-120
X	0.308	0.313		0.310"	0.310"	0.310"	0.316"	Mic	J.F-04
Y	0.760	0.765		0.762"	0.762"	0.762"	0.762"	vern.	J.F-05
Z	0.352	0.372		0.364"	0.367"	0.361"	0.362"	Mic	118-120
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"	R.G.	Ref.
AB	0.615	0.635		0.626"	0.623"	0.624"	0.624"	vern.	J.F-05
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"	R.G.	Ref.
AD	0.240	0.260		0.255"	0.257"	0.260"	0.255"	Mic	118-120
AE	1.375	1.395		1.392"	1.386"	1.389"	1.391"	Dial	HAAS#2
AF	0.115	0.135		0.135"	0.135"	0.135"	0.135"	vern.	J.F-05
AG	0.240	0.280		0.225"	0.225"	0.225"	0.225"	"	
AH	0.240	0.260		0.246"	0.247"	0.249"	0.246"	Mic	118-120
AI	2.000	2.020		2.007"	2.005"	2.005"	2.007"	Dial	HAAS#2
AJ	0.023	0.043		0.033"	0.033"	0.033"	0.033"	vern.	J.F-05
Accept/Reject									

Measured by:	J.F.S.
Date:	11/05/03

Audited by:	J
Date:	11/05/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 67664
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	#10	#11	#12	By	Date
A	0.438	0.443		0.443	0.443	0.443	0.443	Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000	8.000	8.000	Vern	CUC-02
F	0.490	0.510		0.494	0.500	0.499	0.499	Vern	GA-01
G	0.257	0.262		0.258	0.258	0.259	0.259	"	"
H	0.375	0.380		0.376	0.376	0.377	0.377	"	"
I	0.490	0.510		0.500	0.500	0.500	0.500	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.567	0.567	0.567	0.567	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.490	1.500		1.496	1.496	1.495	1.495	"	"
N	2.495	2.505		2.501	2.501	2.500	2.500	"	"
O	3.869	3.879		3.875	3.875	3.874	3.874	"	"
P	0.115	0.135		0.125	0.125	0.127	0.126	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		0.252	0.251	0.251	0.251	"	"
S	0.115	0.135		0.126	0.124	0.127	0.124	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	2.940	2.980		2.961	2.961	2.961	2.961	Vern	GA-01
V	0.230	0.250		0.241	0.240	0.240	0.241	"	"
W	0.115	0.135		0.123	0.121	0.120	0.122	Mic	118-120
X	0.308	0.313		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.763	0.764	0.764	0.764	"	"
Z	0.352	0.372		0.365	0.364	0.366	0.362	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		0.618	0.618	0.618	0.618	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		0.260	0.260	0.260	0.260	Vern	GA-01
AE	1.375	1.395		1.388	1.389	1.388	1.388	Dial	HAA2
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		0.280	0.280	0.280	0.280	"	"
AH	0.240	0.260		0.250	0.248	0.248	0.249	"	"
AI	2.000	2.020		2.003	2.004	2.002	2.002	Dial	HAA2
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	GA-01
Accept/Reject									

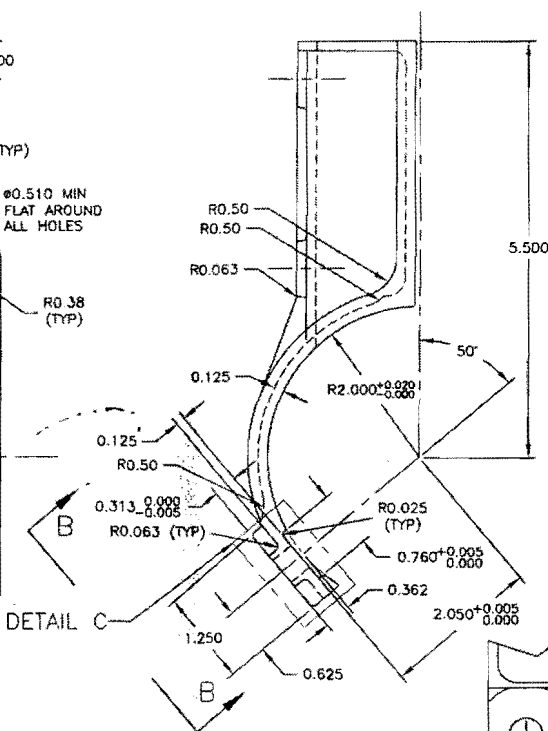
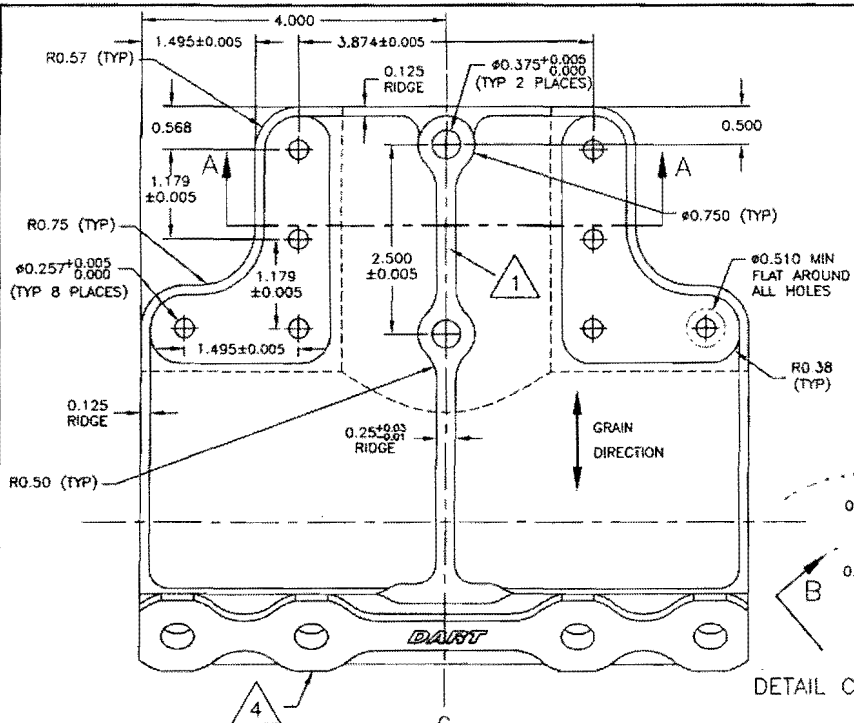
Measured by: H.A.
Date: 11/05/04

Audited by: JL
Date: 11/05/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

#67664

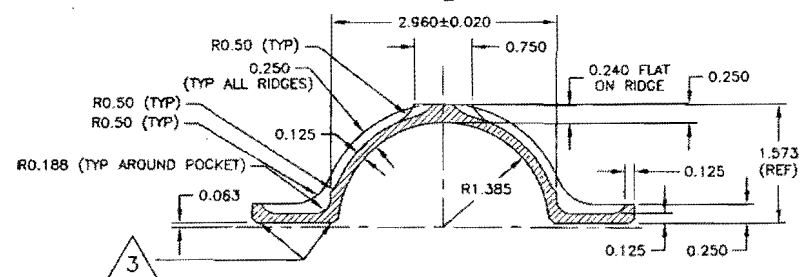
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05.12.06



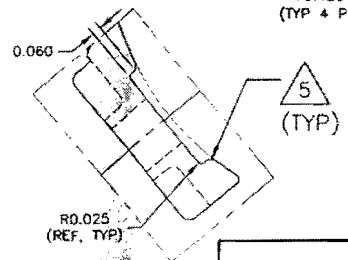
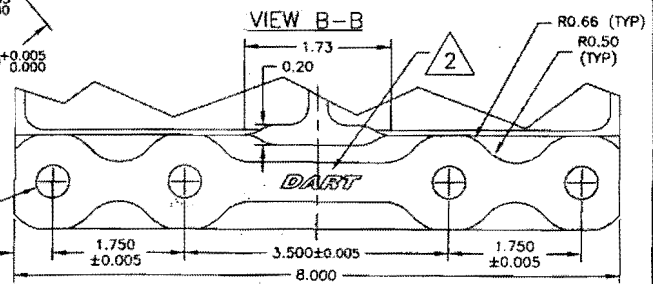
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



SECTION A-A



DETAIL C
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. 02571
		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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HAMMERSLEY, ONTARIO, CANADA